



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>JS</i>	DRAWING NO. DSI 9151	REV. A SHEET 1 of 1
DATE 99.04.01		TITLE D2693 REPAIR SCHEME	SCALE NTS
A	99.04.01	NEW ISSUE	

DART SERVICE INSTRUCTION

AMEND THE FOLLOWING INSTALLATIONS:

IIN-D407-627 REV B
D350-602 REV C

CANADIAN STC: SH98-57
CANADIAN STC: SH93-97

The following repair scheme can be performed to replace D2693 doublers of D2202-3 Pod Base:

- Remove old or damaged doublers.
- Remove paint from any bonding surfaces and clean with TOLUENE or MEK. Lightly abrade with 400 grit abrasive paper and remove the sanding residue with NAPHTHA or MEK. The parts shall be wiped dry with a clean, dry cloth.
- Coat each surface of the components to be bonded with a thin layer of EA934NA adhesive and bond components in position. Remove any excess adhesive squeeze-out.
- Handling strength is achieved in 24 HRS at 70-95 °F while applying a 1.0 psi min vacuum pressure or localized weights.
- Line drill existing holes in pod base through doublers after adhesive has cured.
- Touch up with paint.
- Spray clear lacquer after paint has dried, if desired.

